

Work Order ID 71349

Tuesday, June 28, 2011 1:36:31 PM



Page 1

Item ID: D6005-128

Accept



Setup Start



Revision ID:

Item Name: Crosstube Material

Stop



Start Date: 6/28/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 14.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 11/06/28 Tooling: _____

Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D6005

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 14386

a) Order as per Dwg D6005

b) Material: 2.750 x 0.375 wall 7075-T6/T6511 (WW-T-700/7 or □QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube

c) Minimum ultimate tensile strength = 77 ksi

d) Minimum tensile yield strength = 66 ksi

e) Tolerance are per ASTM B210 (see details on Dwg D6005)

f) Material certification required

110

0.00



Receive & Inspect for Damage & Mat'l Certs

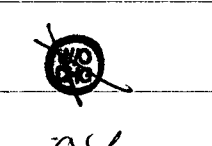
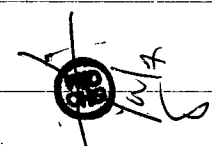
Packaging

Memo

0.00

Packaging

Ensure material certification is attached



CZ 11/06/28 14

Pro →

parts no good
returned to vendor for
credit
12-02-22
u

POSITIVE RECALL

EFFECTIVE 11.11.25 AUTH u

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See pink NCR 1227

Part No: D6005-128 PAR #: _____ Fault Category: Manufacture NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.2.22	110	Found at inspection that tube (Qty +16) were avail. R.C. manufacture	<i>JP</i> 12.02.23	See PAR/D in sheet attaching Have Eng. Approval for available tube PARTS NO RETURNED FOR CREDIT	<i>JP</i> 12.02.23 B51072	<i>W</i>	<i>JP</i> 12.02.23	<i>S</i> 11/11/23
				PAR# C0043101				

NOTE: Date & initial all entries

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Item ID: D6005-128

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Material

Start Date: 6/28/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6005

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

WR 02.23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Tuesday, June 28, 2011 1:36:28 PM

Work Order ID: 71349



Parent Item: D6005-128



Parent Item Name: Crosstube Material


Start Date: 6/28/2011

Required Date: 9/23/2011

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP Rev:C 04.06.15 Added tolerance to Step 2 KJ/JLM
IPP Rev:D 08-09-23 fixe typo in dwg name DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6005-128P  Crosstube material		Purchased	No			110	Each	0.0000	1	14			



Per 11/11/01 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

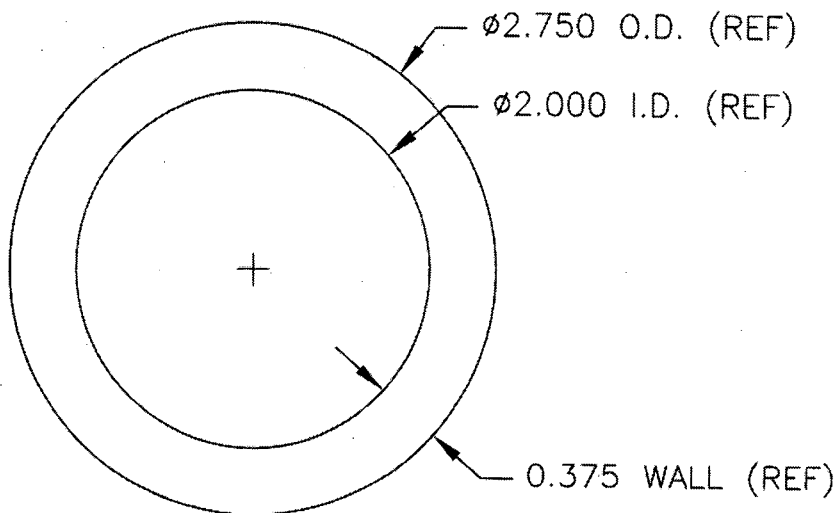
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6005	REV. A SHEET 1 OF 1
DATE 00.11.17		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	00.11.17	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24 *[Signature]*



21/10/28
010:71349

NOTES

- 1) D6005-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 128" LONG TUBE: D6005-128

- 2) MATERIAL: 2.750 OD x 0.375 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.006 MEAN (± 0.012 INCLUDING OVALITY) *G mad*
WALL: ± 0.015 MEAN (± 0.038 INCLUDING ECCENTRICITY)
LENGTH: XXX +0.125/-0.000
STRAIGHTNESS: 0.010 DEVIATION / 12" LENGTH
- 4) ~~EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.~~
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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